



A PROFESSIONAL CORPORATION
9100 THREE GALLERIA TOWER
13155 NOEL ROAD
DALLAS, TEXAS 75240

TELEPHONE (972) 628-3600

FACSIMILE (972) 628-3616

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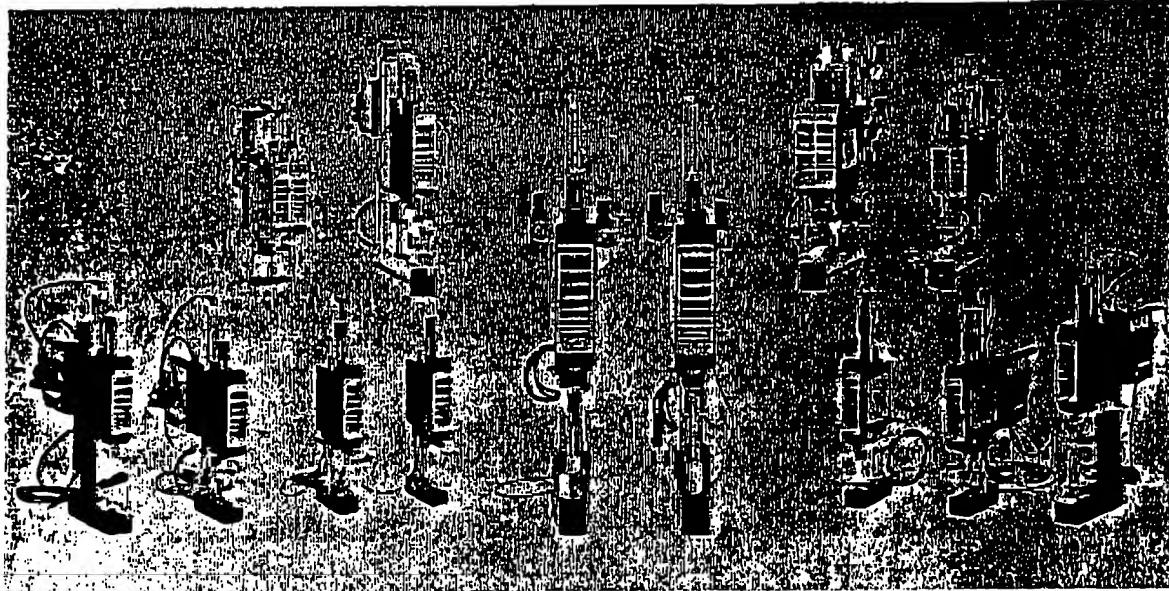
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WELD HEADS

THIN-LINE™ WELD HEADS

HIGH PERFORMANCE, DURABILITY & LONG LIFE

80 SERIES, 180 SERIES, 90 SERIES

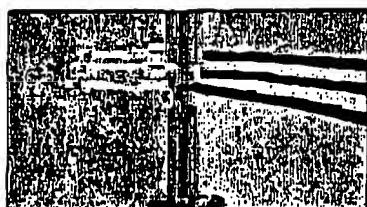


Thin-Line Features

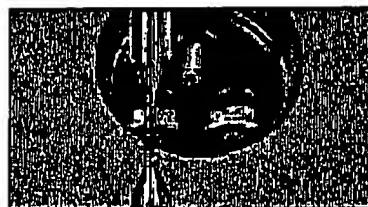
- Adjustable Force-Firing
- Low Inertia Designs
- Air Actuation Option
- Adjustable Tare Spring
- Single Air Regulator (Series 80)
- Up to 1.5 Inch (38mm) Stroke
- Up and Down Stops
- Rugged Design
- EZ-AIR® Technology

Benefits

- Permits high quality, precision small parts welding since welding force is independent of electrode stroke.
- Improves weld consistency, reduces metal expulsion, and improves the appearance of the weld.
- Integrates easily into automated work stations and provides rates exceeding one weld per second at maximum weld force.
- Allows use of custom electrodes without sacrificing performance.
- Simplifies adjustment and increases speed of air actuated heads.
- Allows welding inside deep cavities.
- Increases production rates by allowing user to optimize upper electrode motion.
- Improves productivity, minimizes repair costs and ensures long life.
- Improves consistency and simplifies set-up.



Weld stranded copper wire securely to
relay leads or electrical terminals



Weld electrical terminals to solid wire leads



Prismatic NiCd Battery Assembly

PRECISION PERFORMANCE THROUGH INTELLIGENT DESIGN

The Thin-Line Ranges

Unitek Peco Thin-Line Weld Heads consist of three families of full-featured products for precision metals joining:

80 Series - 20 lb. (89N)

40 lb. (178N)

180 Series - 100 lb (445 N)

90 Series - 150 lb (667N)

All are precision, low inertia, force-fired designs, with a narrow vertical profile. They are ideal for both production line and bench applications and can operate at speeds greater than 3600 welds per hour.

Durable High Quality Design

Rugged construction, linear ball bearing bushings and an **over-sized, anti-rotation bearing system** provide perfect linear travel of the upper electrode arm. This system

minimizes the potential for electrode wiping action during the weld, even at maximum force settings. Based on actual test data, **bearing life exceeds 25 million operations** when used according to the specifications.

High Speed Capability

A top-mounted air actuation system, with a regulator and dual flow controls, ensures repeatable, reliable, high-speed operation in automated applications. Threaded holes on the back of the heads make them easy to mount, without their post or base, in automated work stations. EZ-AIA provides unsurpassed repeatability and ease of set-up.

Precision Control

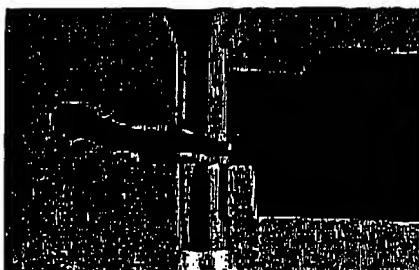
Thin-Line Weld Heads add consistency and control to complex welding applications.

Their **low inertia designs** ensure the fast dynamic response required for the electrodes to follow the minute expansion and contraction of the weld joint as it heats and cools. A **differential motion force-firing** system initiates the welding control at the precise moment when the pre-set electrode force is applied to the workpieces.

Electrodes and Accessories

A complete line of accessories and electrodes are available. Refer to the accessories data sheet 991-160. Optics are available for all heads. All heads are supplied with welding cables, firing switch cables, mounting hardware, and one set of electrodes.

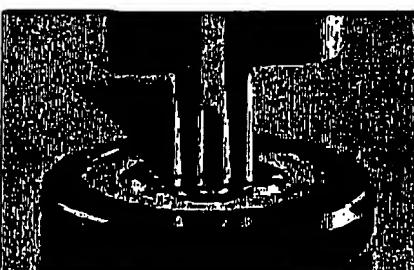
ELECTRODE CONFIGURATIONS MATCH SPECIFIC APPLICATION NEEDS



Opposed Weld

Opposed Configuration

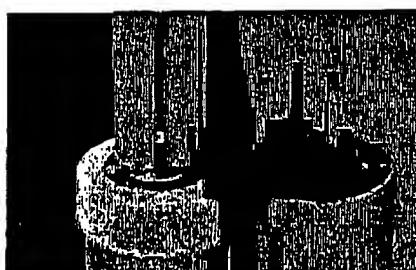
Top and bottom electrodes are used to hold the parts and provide the current path. An **opposed weld** is preferred over other configurations because it is easier to set-up and control the current path. It should be used whenever possible.



Series Weld

Series Configuration

Using two top electrodes, a series weld can be used when there is no access to the bottom part. Both electrodes contact the top part and current is passed through the top part to the bottom part. Two weld spots are produced, one under each electrode. Independent force control allows for separate adjustment of each electrode force and is used to balance the heat between the two weld spots.

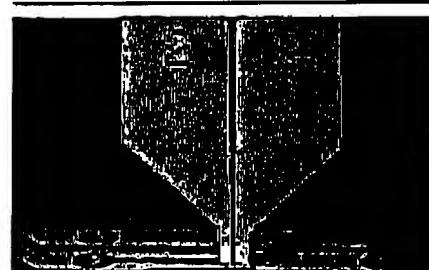


Step Weld

Step Configuration

Thin-Line weld heads designed for series welding can also be set up in a step configuration. Two top electrodes are

used, but one electrode contacts the top part and the other electrode contacts the bottom part. A single weld is produced at the part to part interface. Independent force control allows the electrode force on the bottom part to be set much higher than the force on the top part.



Parallel Gap Weld

Parallel Gap Configuration

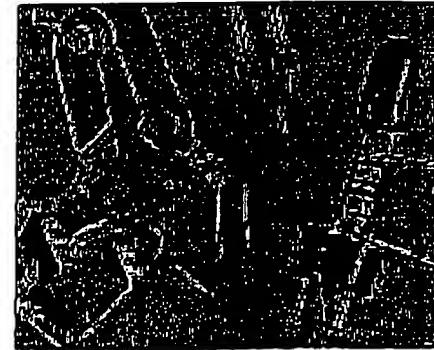
Parallel gap welding results in a single weld spot under the gap between the electrodes. It is used to weld very small parts. Two styles of parallel gap electrodes are available: Unitips® which are permanently bonded together with an insulating spacer and fixed gap; and Unibond Electrodes® which allow for adjustment of the gap.

HIGH QUALITY, FULL FEATURED

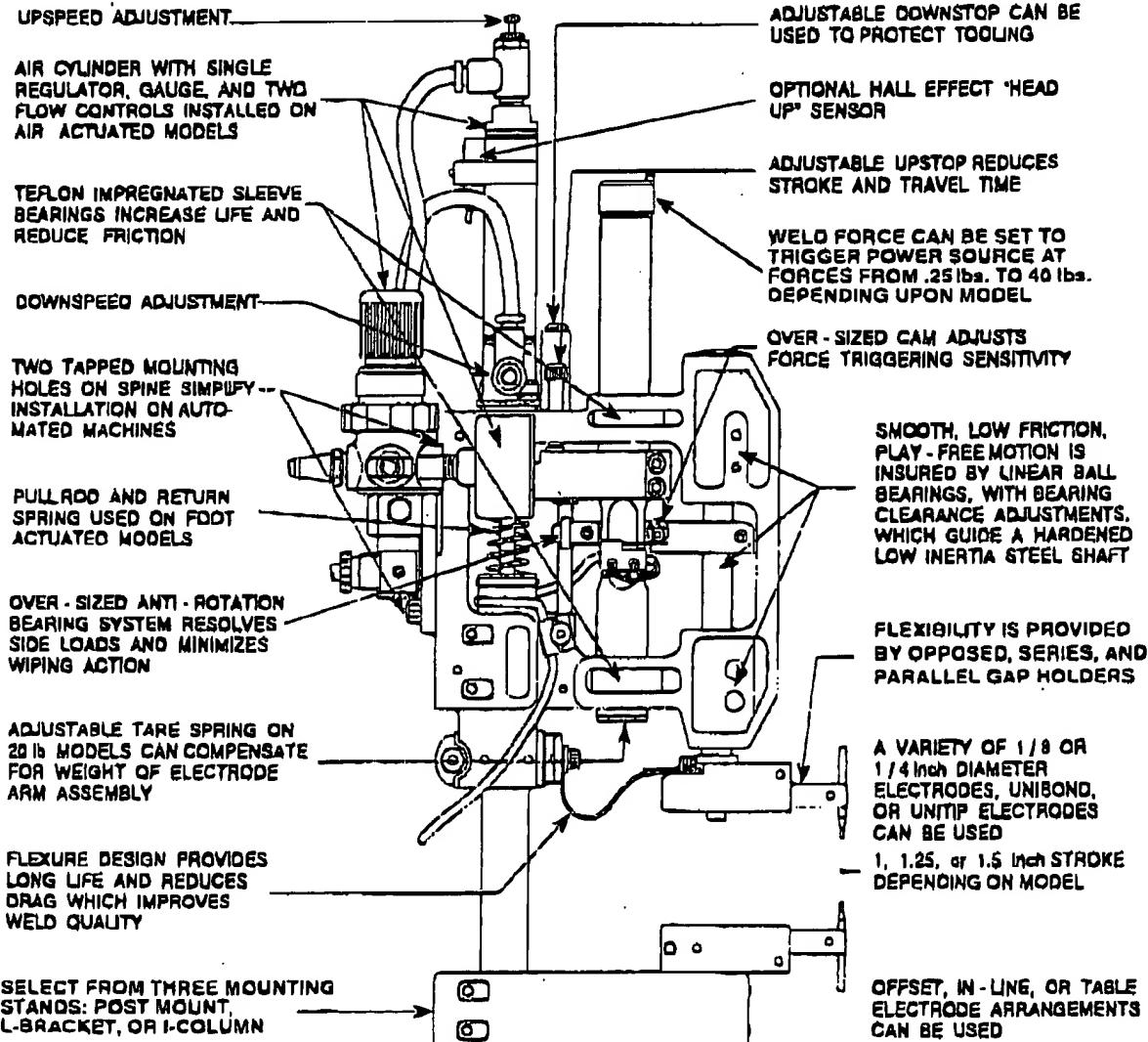
The 80 Series (below), 180 Series, and 90 Series are subjected to environmental life testing designed to guarantee specifications and performance.

Air actuated heads are supplied with an air pressure regulator, two flow controls which are used to independently control the up and down velocity, and a 24-volt AC solenoid (115 volts is an available option). The air actuation system includes a linear spring

which ensures proper operation at low forces. EZ-AIR provides high repeatability and eliminates overforce. The air systems can be moved to other locations when the heads are incorporated in work stations or automated systems. The heads can be supplied with an optional Hall Effect Limit Switch Kit, which will detect when the head is in the up or down position. This feature can prevent damage when automated machine tooling is indexed.



80 SERIES DESIGN FEATURES



80 SERIES THIN-LINE WELD HEADS

80 SERIES THIN-LINE WELD HEADS – FORCE RANGE 0.25 TO 20 LBS (1.1 TO 89 N)

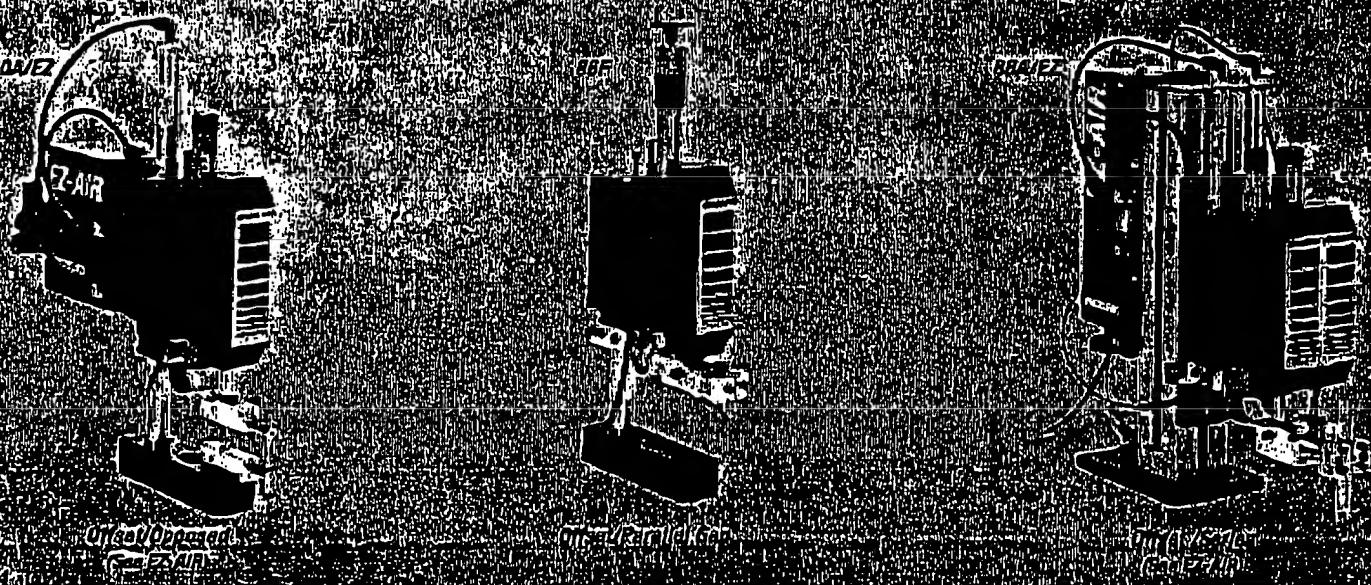
FEATURE	UNIT OF MEASURE							
Standard Model	80F1	80A	86F2	86A2	87F1	87A	88F	88A
EZ-AIR Model (Complete Weld Head) ³		80A/EZ		86A/EZ		87A/EZ		88A/EZ
Actuation	Manual	Air	Manual	Air	Manual	Air	Manual	Air
Weld Force	Maximum lbs (N)	20 (89)	20 (89)	20 (89)	20 (89)	20 (89)	20 (89)	20 (89)
	Minimum lbs (N)	.25 (1.1)	.5 (2.2)	.25 (1.1)	.5 (2.2)	.25 (1.1)	.5 (2.2)	.5 (2.2)
Maximum Rating	KVA (Watt-Seconds)	2 (250)	2 (250)	1 (125)	1 (125)	2 (125)	2 (125)	5 (250)
Maximum Electrode Stroke	Inch (mm)	1 (25)	1 (25)	1 (25)	1 (25)	1 (25)	1 (25)	1 (25)
Electrode Diameter	Inch (mm)	.125 (3.2)	.125 (3.2)	Unibond Unitips	Unibond Unitips	Thermodes Unitips	Thermodes Unitips	0.245 (6.2) 0.245 (6.2)
Electrode Configuration	Opposed	Opposed	Parallel Gap	Parallel Gap	Parallel Gap	N/A	Series	Series
Electrode Holder Type	Offset	Offset	Offset	Offset	Offset	Offset	Offset	Offset
Maximum Throat Size (H x D)	Inch (mm)	1.94 x 6.0 (49 x 152)	1.84 x 6.0 (49 x 152)	3.38 x 6.19 (88 x 132)	3.38 x 6.19 (88 x 132)	2.55 x 5.25 (65 x 133)	2.55 x 5.25 (65 x 133)	6.2 x 6.25 (157 x 159)
Maximum Gap between Electrodes	Inch (mm)	– –	– (1.0)	0.040 (1.0)	0.040 (1.0)	0.040 (1.0)	0.040 (1.0)	1.75 (44.5)
Electrode Series	ES-0400	ES-0400	EU or UT	EU	17 ⁴ or UT	17 ⁴	ES-0800E	ES-0800E
Weld Cable Size & Length	AWG Inch (cm)	#2 11 (28)	#2 11 (28)	#2 11 (28)	#2 11 (28)	#2 11 (28)	#2/0 11 (28)	#2/0 11 (28)
Foot Pedal Model	CP	–	CP	–	CP	–	MSP	–
Footswitch Model	–	–	FSAC, FS1L, FS2L	–	FSAC, FS1L FS2L	–	FSAC, FS1L FS2L	FS1L FS2L
Air Solenoid Voltage	VAC	–	24 or 115	–	24 or 115	–	24 or 115	–
Air Pressure for Maximum Force	psig (bar)	–	65 (4.5)	–	65 (4.5)	–	65 (4.5)	–
Air Cylinder Inside Diameter	Inch (mm)	–	.75 (19)	–	.75 (19)	–	.75 (19)	–
Cycle Rate: @ Minimum Force	Full Strokes/sec	–	1	–	1	–	1	–
@ > 20% of Rated Force	Full Strokes/sec	–	2.5	–	2.5	–	2.5	–
Maximum Dimensions (including stand & Air Kit)	Height – Inch (mm)	13.7 (348)	18.3 (414)	16 (406)	16.5 (419)	16 (406)	18.5 (419)	18.7 (424)
	Depth – Inch (mm)	7.6 (193)	9.0 (229)	7.8 (193)	9.1 (231)	7.0 (178)	9.1 (231)	13.5 (343)
	Width – Inch (mm)	1.7 (43)	4.6 (117)	2.2 (56)	4.7 (119)	2.2 (58)	4.7 (119)	4 (102)
Weight (before packing)	Lbs (kg)	5 (2.3)	7 (3.2)	5.5 (2.5)	7 (3.2)	5.5 (2.5)	7 (3.2)	14 (6.4)
								17 (7.7)

(1) Model 80FLF and 87FLF have a force range of 0.25–10 lbs (1.1–44.5N).

(2) Model 86FRE and 88ARE use 1/8 inch (3.2mm) diameter Series ES-0400-35° Offset Electrode Holders and Electrodes.

(3) See page 7 for EZ-AIR specifications.

(4) 17BM, 17F, 17M, 17P or 17SP

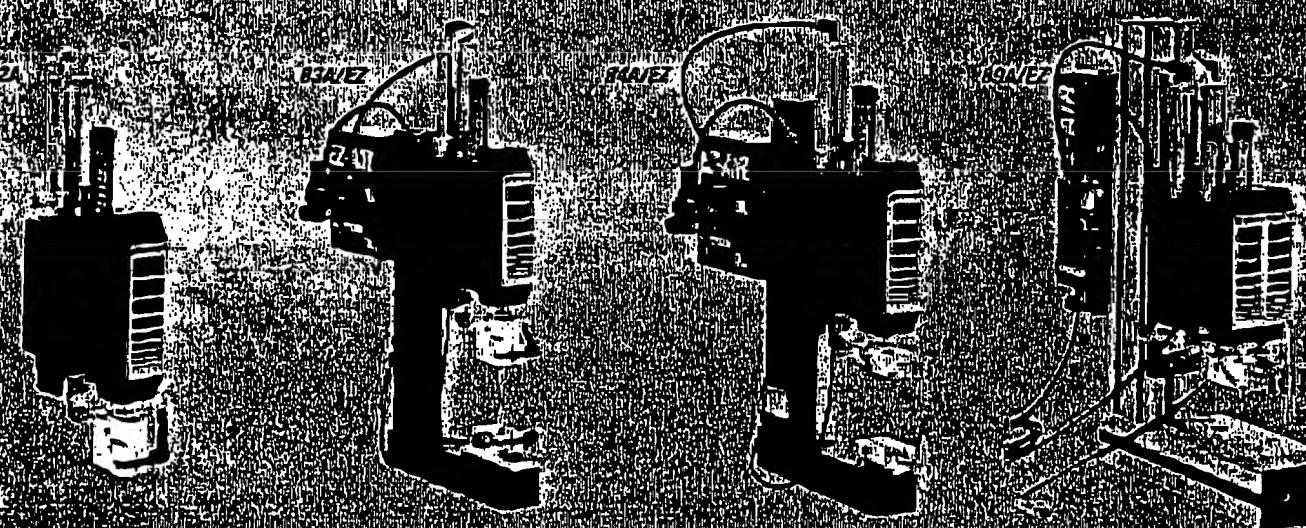


80 SERIES THIN-LINE WELD HEADS**80 SERIES THIN-LINE WELD HEADS – FORCE RANGE 4 TO 40 LBS (18 TO 178 N)**

FEATURE	UNIT OF MEASURE						
Standard Model	82A1	83F	83A	84F	84A	89F	89A
EZ-AIR Model (Complete Weld Head) ²			83A/EZ		84A/EZ		89A/EZ
Actuation	Air	Manual	Air	Manual	Air	Manual	Air
Weld Force	Maximum lbs (N)	40 (178)	40 (178)	40 (178)	40 (178)	40 (178)	40 (178)
	Minimum lbs (N)	6 (27)	4 (18)	6 (27)	4 (18)	6 (27)	4 (18)
Maximum Rating	KVA (Watt-Seconds)	5 (250)	5 (250)	5 (250)	5 (250)	5 (250)	5 (250)
Maximum Electrode Stroke	Inch (mm)	1 (25)	1 (25)	1 (25)	1 (25)	1 (25)	1 (25)
Electrode Diameter	Inch (mm)	.25 (6.4)/ .125 (3.2)	.25 (6.4)/ .125 (3.2)	.25 (6.4)	.25 (6.4)	0.245 (6.2)	0.245 (6.2)
Electrode Configuration	Opposed	Opposed	Opposed	Opposed	Opposed	Series	Series
Electrode Holder Type	In-Line	In-Line	In-Line	Offset	Offset	Offset	Offset
Maximum Throat Size (H x D)	Inch (mm)	N/A	1.8 x 3.1 (46 x 79)	1.8 x 4.8 (46 x 122)	3.3 x 6.1 (84 x 155)	3.3 x 7.8 (84 x 198)	8.7 x 5.6 (221 x 142)
Maximum Gap between Electrodes	Inch (mm)	–	–	–	–	1.75 (44.5)	1.75 (44.5)
Electrode Series	ES-0800/ ES-0400	ES-0800/ ES-0400	ES-0800/ ES-0400	ES-0800	ES-0800	ES-0800E	ES-0800E
Weld Cable Size & Length	AWG Inch (cm)	#2/0 11 (28)	#2/0 11 (28)	#2/0 11 (28)	#2/0 11 (28)	#2/0 11 (28)	#2/0 11 (28)
Foot Pedal Model	–	MSP	–	MSP	–	MSP	–
Footswitch Model	–	FSAC, FS1L, FS2L	–	FSAC, FS1L FS2L	–	FSAC, FS1L FS2L	–
Air Solenoid Voltage	VAC	24 or 115	–	24 or 115	–	24 or 115	–
Air Pressure for Maximum Force	psig (bar)	55 (3.8)	–	55 (3.8)	–	55 (3.8)	–
Air Cylinder Inside Diameter	Inch (mm)	1.0625 (27)	–	1.0625 (27)	–	1.0625 (27)	–
Cycle Rate: @ Minimum Force	Full Strokes/sec	1	–	1	–	1	–
@ > 20% of Rated Force	Full strokes/sec	2.5	–	2.5	–	2.5	–
Maximum Dimensions (Including stand & Air Kit)	Height – Inch (mm)	18.2 (411)	17.4 (442)	20.1 (511)	16.7 (424)	19.3 (490)	21.9 (556)
	Depth – Inch (mm)	17.7 (450)	7.9 (201)	9.5 (244)	10.0 (254)	11.9 (302)	14.6 (371)
	Width – Inch (mm)	4.6 (117)	2.6 (66)	4.6 (117)	2.6 (66)	4.6 (117)	4.9 (124)
Weight (before packing)	Lbs (kg)	5 (2.3)	7 (3.2)	9 (4.1)	8 (3.6)	10 (4.5)	20 (9.1)
							23 (10.4)

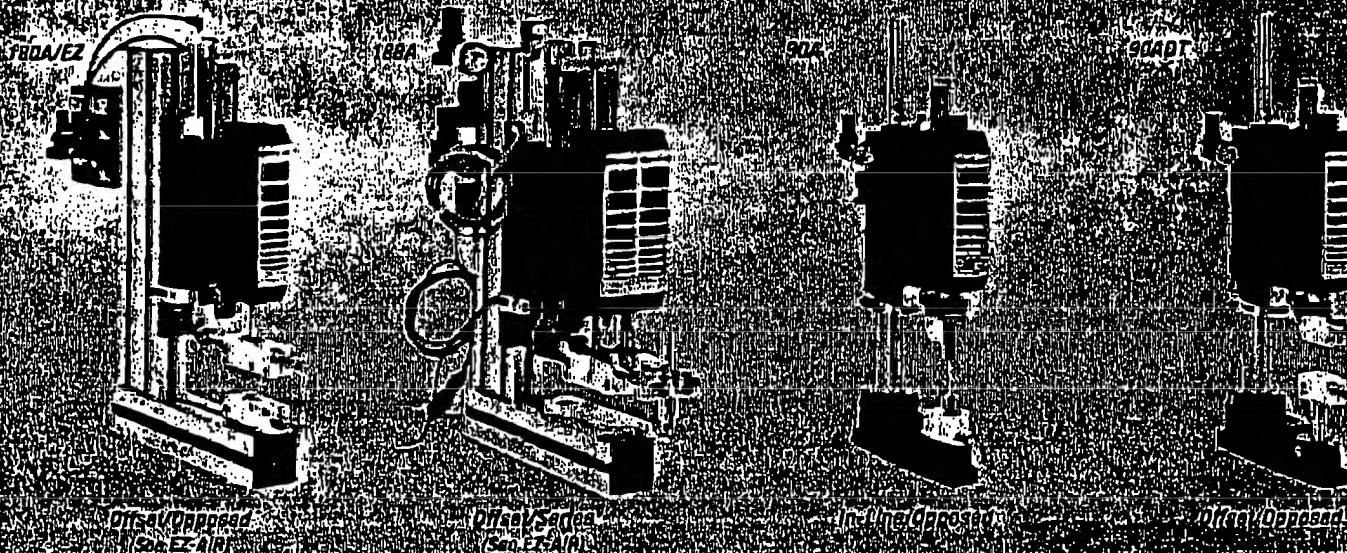
(1) Model 82A is the same as Model 83A with the mounting stand, lower electrode holder and lower electrode omitted.

(2) See page 7 for EZ-AIR specifications.

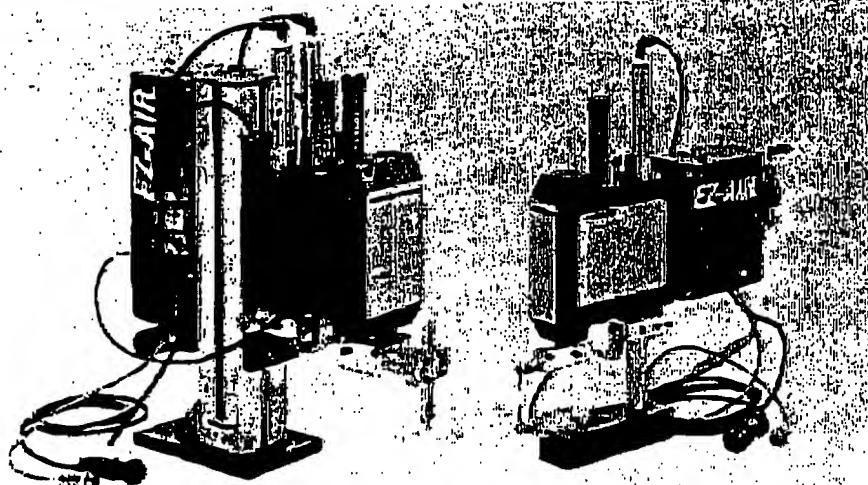


180 & 90 SERIES THIN-LINE WELD HEADS**180 SERIES MID-FORCE WELD HEADS**
FORCE RANGE 5 TO 100 LBS (22 TO 445 N)**90 SERIES HIGH-FORCE WELD HEADS**
FORCE RANGE 7 TO 150 LBS (31 TO 667 N)

FEATURE	UNIT OF MEASURE					
Standard Model	180F	180A	182A	188A	90A	90ADT
EZ-AIR Model (Complete Weld Head) ¹		180A/EZ		188A/EZ		
Actuation	Manual	Air	Air	Air	Air	Air
Weld Force	Maximum lbs (N)	100 (445)	100 (445)	100 (445)	150 (667)	100 (445)
	Minimum lbs (N)	5 (22)	5 (22)	5 (22)	7 (31)	7 (31)
Maximum Rating	KVA (Watt-Seconds)	20 (875)	20 (875)	20 (875)	30 (1000)	20 (875)
Maximum Electrode Stroke	Inch (mm)	1.25 (32)	1.25 (32)	1.25 (32)	1.5 (38)	1.5 (38)
Electrode Diameter	Inch (mm)	.25 (6.4)	.25 (6.4)	.25 (6.4)	.25 (6.4)	.25 (6.4)
Electrode Configuration	Opposed	Opposed	Opposed	Series	Opposed	Opposed
Electrode Holder Type	Offset	Offset	In-Line	Offset	In-Line	Offset
Maximum Throat Size (H x D)	Inch (mm)	6.1 x 8.5 (154.9 x 215.9)	6.1 x 11.1 (154.9 x 281.9)	2.8 x 6.3 (71.1 x 180.0)	8.0 x 11.5 (152.4 x 282.1)	2.125 x 6.2 (54.0 x 157) (146.1 x 279.4)
Maximum Gap between Electrodes	Inch (mm)	- -	- -	- -	3.0 (76.2)	- -
Electrode Series	ES-0800	ES-0800	ES-0800	ES-0800E	ES-0800	ES-0800
Weld Cable Size & Length	AWG Inch (cm)	#2/0 16 (41)	#2/0 16 (41)	#2/0 16 (41)	#2/0 16 (41)	#2/0 16 (41)
Foot Pedal Model	MSP	-	-	-	-	-
Footswitch Model	-	FSAC, FS1L FS2L	FSAC, FS1L FS2L	FSAC, FS1L FS2L	FSAC, FS1L FS2L	FSAC, FS1L FS2L
Air Solenoid Voltage	VAC	-	24 or 115	24 or 115	24 or 115	24 or 115
Air Pressure for Maximum Force	psig (bar)		60 (4.4)	80 (4.4)	60 (4.4)	60 (4.4)
Air Cylinder Inside Diameter	Inch (mm)	1.5 (38.1)	1.5 (38.1)	1.5 (38.1)	1.0625 (27)	1.0625 (27)
Cycle Rate: @ Minimum Force @ > 20% of Rated Force	Full Strokes/sec	-	1	1	1	1
	Full Strokes/sec		2	2	2	1.5
Maximum Dimensions (including stand & Air Kit)	Height - Inch (mm) Depth - Inch (mm) Width - Inch (mm)	24 (610) 14.9 (378) 3.1 (79)	24.75 (629) 16.5 (419) 6.8 (168)	25 (635) 13.4 (340) 6.4 (163)	24.9 (632) 18.1 (460) 6.8 (168)	31.1 (790) 13 (330) 6.6 (168)
Weight (before packing)	Lbs (kg)	18.5 (8.4)	21.5 (9.8)	21.5 (9.8)	36.5 (16.6)	37.5 (17)
						38.5 (17.5)

¹ See page 2 for EZ-AIR specifications.

EZ-AIR TECHNOLOGY



The EZ-AIR weld force control system simplifies the set-up process to a single adjustment and helps prevent weld over-force by closing off the input air when the actual weld force reaches the programmed weld force level, delivering accurate force control which is repeatable across multiple weld heads without complex setup or operator training.

- Firing force is important because it controls contact resistances and, therefore, heat generation at the electrode-to-part and part-to-part interface.
- Superior force control = process stability and higher production yield with reduced maintenance time.

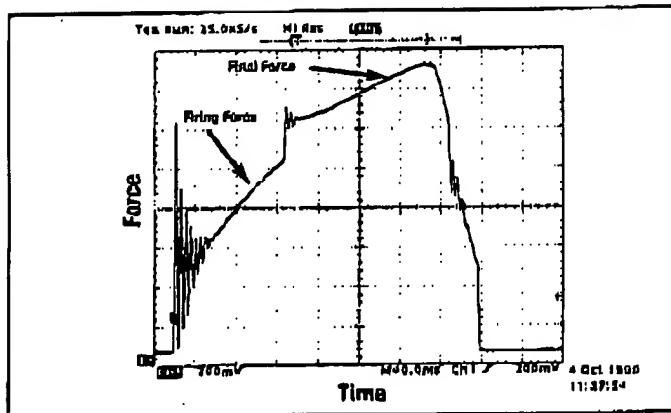
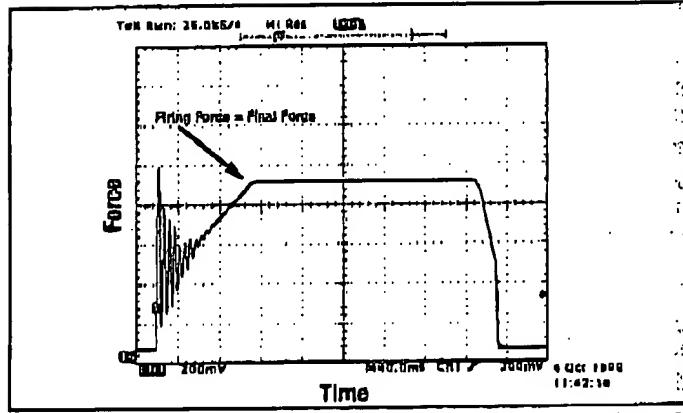
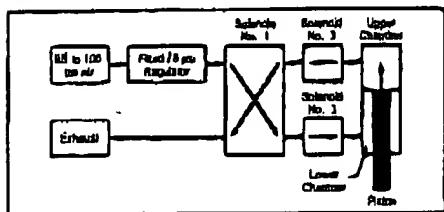


Figure 1, above, shows an incorrect balance of firing force to air pressure set by an operator after cleaning the electrodes, on a traditional weld head, resulting in poor set-up and force control.

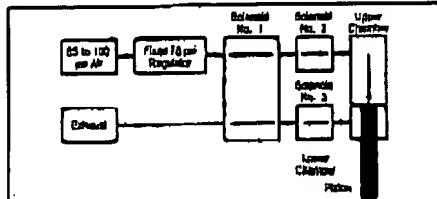


EZ-AIR insures correct set-up and good force control as seen in Figure 2, above. The Unitek Paco EZ-AIR requires no balancing of air pressure as the air pressure is constant once the firing force is reached.

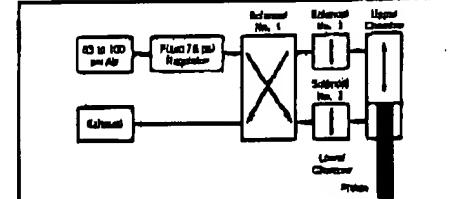
The following series of simplified diagrams explain how the EZ-AIR weld force control system works through independent control of upper and lower air chambers.



Electrode up position – air pressure in the lower chamber keeps the piston in the up position. Waste air exhausts from the upper chamber.



Electrode moves down – air pressure in the upper chamber forces the piston down. Waste air exhausts from the lower chamber.



Electrode reaches weld force – both solenoid valves close within 4ms and air pressure is trapped in both the upper and lower chambers. Weld force remains constant since the air cylinder piston cannot move. Compression spring provides instantaneous follow-up.



EZ-AIR force control technology is available with Unitek Paco Thin-Line weld heads as original equipment and as a retrofit for previously purchased Thin-Line air actuated weld heads. See the Ordering Guide for more information.

THIN-LINE WELD HEAD ORDERING GUIDE

MODEL	DESCRIPTION				
WELD HEADS	Weld head, manual or air actuation, or EZ-AIR model, please refer to Weld Head Table, pages 4, 5 and 6, for model numbers and specifications. For air actuation, add /24 for 24 VAC or /115 for 115 VAC solenoid. Example: 80A/24, Model 80A with 24 VAC solenoid. For EZ-AIR model, add /EZ. Example: 80A/EZ, Model 80A with EZ-AIR.				
FOOT ACTUATORS	Model	Head Type	Description		
	FS1L	Air or EZ-AIR	Footswitch, single level (for all pneumatic weld heads).		
	FS2L	Air or EZ-AIR	Footswitch, two level (for all pneumatic weld heads).		
	FSAC	Air (115 VAC)	AC Footswitch, single level. Switches 115VAC-50/60Hz to air which does NOT have a built-in valve driver.		
	CP	Manual	Cable pedal, rated: 25 lbs., 1" stroke, with 6-foot cable (for models 80F, 88F, or 87F).		
	MSP	Manual	Foot pedal, medium force swing type, rated: 100 lbs., 5:1 mechanical advantage (for models 83F, 84F, 88F, 89F, or 180F).		
HEAD OPTIONS & ACCESSORIES	Model	Type	Description		
	HS20	Option	Hall effect sensor kit for 20 lb. cylinders. Includes: cylinder, clamp, and sensor. Use on 80A, 86A, 87A, 88A, 88A requires two kits.		
	HS40	Option	Hall effect sensor kit for 40 lb. cylinders. Includes: cylinder, clamp, and sensor. Use on 82A, 83A, 84A, 89A, 89A requires two kits.		
	DFS	Accessory	Firing switch junction box. Connects two firing switch cables in parallel to one power supply.		
	DFS/88	Accessory	Series firing switch junction box. Connects two firing switch cables in series (included in models 88, 89, and 188).		
	BPTL	Accessory	Base plate, anodized. Supports optic mounting assembly.		
VIEWING ACCESSORIES					
OMA	Optic mounting assembly. Use with NIKON, and BPTL.				
NIKON	Optic, stereo zoom, NIKON, 10X eyepiece, 0.5X auxiliary objective lens.				
BLFO!	Fiber optic illuminator system, 115V-50/60Hz. Self-supporting gooseneck, bifurcated light pipes, focusing lenses and mounting adapter for optic mounting assembly.				
BLFO/230	Fiber optic illuminator system, 230V-50/60Hz. Self-supporting gooseneck, bifurcated light pipes, focusing lenses for mounting adapter for optic mounting assembly.				
PROCESS SET-UP TOOLS					
	FG20	Electrode force gage, 20 lb., scale 20 lb. x 0.2 lb.			
	FG100	Electrode force gage, 100 lb., scale 100 lb. x 1 lb.			
	FG200	Electrode force gage, 200 lb., scale 200 lb. x 2 lb.			
	FG10KG	Electrode force gage, 10 kg., scale 10 kg. x 0.1 kg.			
	FG100KG	Electrode force gage, 100 kg., scale 100 kg. x 1 kg.			
All available with or without serial number.					
MISCELLANEOUS ACCESSORIES					
	UTA	Unitip adapter, allows use of Unitip electrodes in model 88.			
	WP	Work Positioner, 3-inch diameter. Height adjustable from 1-7/16 to 2 inches (models 86, 87, 88, 89).			

EZ-AIR SPECIFICATIONS

DESCRIPTION	SPECIFICATION
Force Adjustment Range Models: 80A/EZ, 86A/EZ, 88A/EZ	1 to 20 lbs (4.4 to 89N)
Force Adjustment Range Models: 83A/EZ, 84A/EZ, 89A/EZ	4 to 40 lbs (17.8 to 178N)
Force Adjustment Range Models: 180A/EZ	5 to 100 lbs (22 to 445N)
Valve Driver Input	24 VAC
Input Air Pressure	85 to 130 psi (602 kPa to 898 kPa), unlubricated air
ORDERING GUIDE	
With a Weld Head	Specify XEA/EZ where XEA is the weld head (80, 83, 84, 86, 88, 89, 180). Example: 80A/EZ for an 80 Thinline Weld Head
As a Retrofit Kit	Specify EZ/SAK for use with a head with a single air cylinder. Specify EZ/DAK for use with a head with dual (two) air cylinders.

Your Local Representative



A UNITEK MIYACHI INTERNATIONAL COMPANY

Corporate Office: 1820 S. Myrtle Ave. • P.O. Box 5033 • Monrovia, CA 91017-7133 USA
 Tel: (626) 303-5678 • FAX: (626) 358-8048 • E-Mail: Info@unitekequipment.com
 Internet <http://www.unitekequipment.com>

EASTERN (USA) Sales Office: 21 Cummings Park, Suite 252 Woburn, MA 01801 Tel: (781) 938-0442 FAX: (781) 935-1485 E-Mail: eastgases@unitekequipment.com	NORTH ASIA Sales Office: Unit 0, 20/F, Infotech Centre 21 Hung To Road Kwun Tong, Hong Kong Tel: +852 2833-6898 FAX: +852 2833-6872 E-Mail: asiapacific@unitekequipment.com	UNITEK EAPRO: Schoolerlaer Dreef 21 NL-5708 HZ Helmond The Netherlands Tel: +31 482-54-22-25 FAX: +31 492-53-82-22 E-Mail: info@unitekeapro.com	PECO WELDING SYSTEMS GmbH Lindberghstrasse 1 D-82178 Puchheim Germany Tel: +49-89 89 94 03 79 FAX: +49-89 89 94 03 88
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